

Date: Wednesday, 25/03/2009 10:54:42 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: TUBE		
Job Number	: 46689					
Estimate Number	: 11168					
P.O. Number	:		Part Number	: D22823		
This Issue	25/03/2009	S.O. No. :	Drawing Number	: D2282 REV E		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: / /	Type : MACHINED PARTS	Drawing Revision	: E		
Previous Run	: 46428		Material	:		
Written By	: <i>JL 08-03-25</i>		Due Date	: 01/04/2009 Qty: 50 Um: Each		
Checked & Approved By	:					
Comment	: Est Rev:A		Removed from 9 Digit	05-12-02	JLM	

## Additional Product

Job Number:		
Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0675W091	304 RD Tube .675 x .091W 
<b>Comment:</b> Qty.: 0.2078 f(s)/Unit Total: 10.3898 f(s) <b>Material:</b> T304/T316 3/8 Schedule 40, Seamless, Ø0.675" OD, 0.091" wall thickness (M304TR0.675W.091) <b>Batch</b> <i>M110550</i> <i>SD 08/03/25</i> <i>10.41f</i>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL 
<b>Comment:</b> HARDINGE CNC LATHE SMALL 1-Turn as per Dwg D2282 and Folio FA188 2-Deburr <i>SD 08/03/25</i> <i>(54)</i>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <i>SD 09/03/27</i> <i>(54)</i>		
4.0	QC8	SECOND CHECK 
<i>2/20 = 09/03/30</i> 		
<b>Comment:</b> SECOND CHECK		
5.0	PACKAGING 1	PACKAGING RESOURCE #1 
<b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location: <i>Carl L.</i> <i>SD 09/03/31</i> <i>(54)</i>		

Date: Wednesday, 25/03/2009 10:54:43 AM  
User: Jean-Luc Menard

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 46689

Part Number: D22823

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



09/04/01 AF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-03-31

DART AEROSPACE LTD	Work Order:	416689
Description: Handle Tube	Part Number:	D2282-3
Inspection Dwg: D2282 Rev: E		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

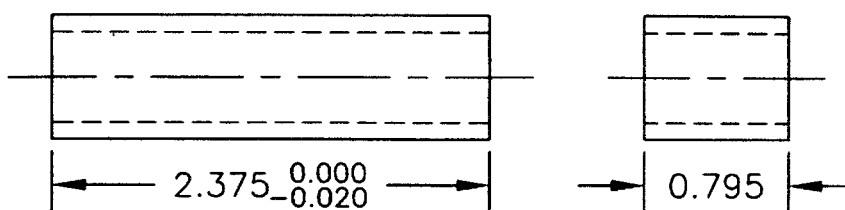
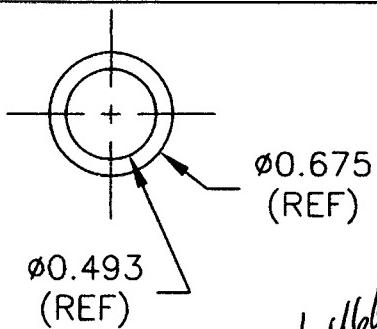
## X First Article Prototype

Measured by:	SJ	Audited by:	mnr/gmf	Prototype Approval:	N/A
Date:	09/03/29	Date:	09/03/29	Date:	N/A

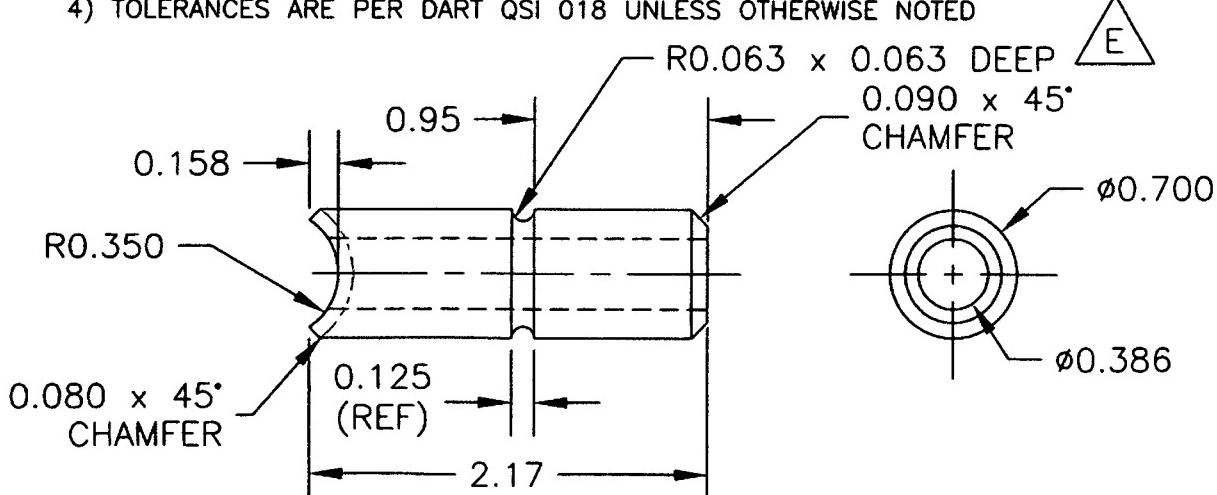
Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
B	05.04.19	Tolerance changed	KJ/JLM	
C	06.03.15	Dwg Rev update	KJ/JLM	KA SJ

**DART**

DESIGN BW	DRAWN BY <i>PZ</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <i>IP</i>	APPROVED <i>100%</i>	DRAWING NO. D2282
DATE 05.06.07	TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE
B	95.03.23	RE-DESIGN
C	97.10.20	CORRECTED NUMBERING SCHEME
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

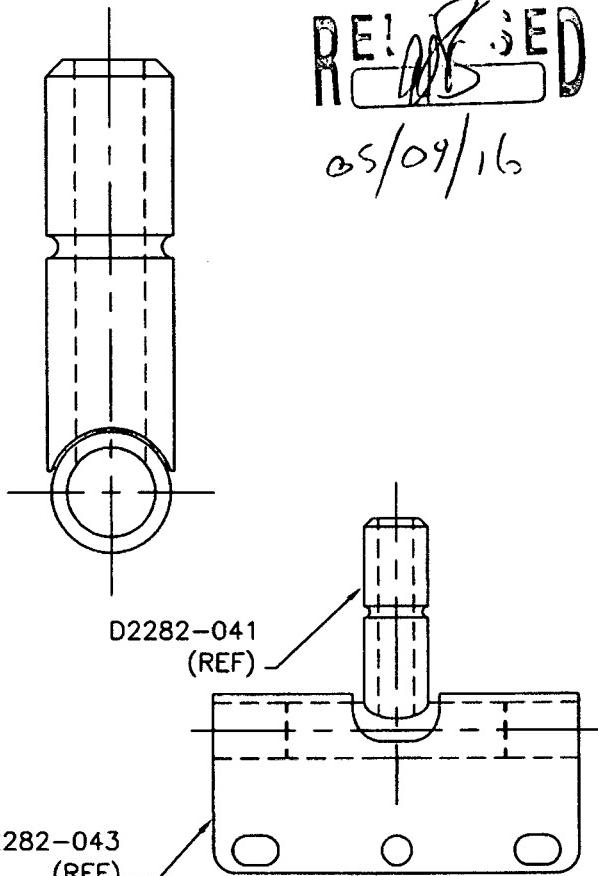
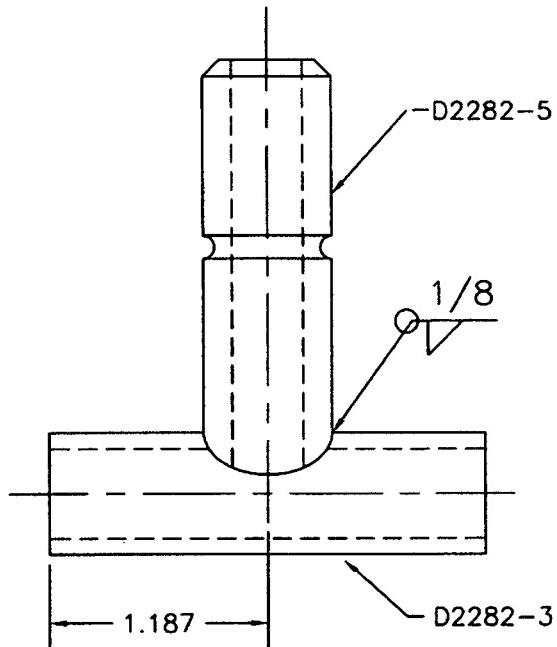
**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

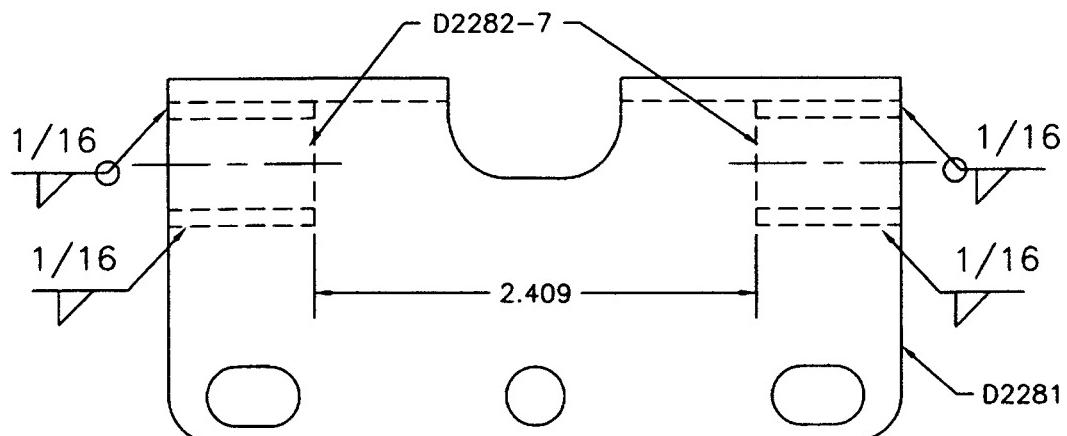
**E**

**DART**

DESIGN BW	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>AM</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



**D2282-041 'T' ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004



**D2282-043 SADDLE ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004